

Work Order ID 67314

Page 1

Tuesday, March 15, 2011 10:14:33 AM

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*H*Date: *4-03-15*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

*8 u/03/15**4/4/15 BG 11-3-18**(2)*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/3/21 (2x) sf

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*8 u/03/21**(x2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Packaging	Packaging	0.00							
	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
130 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 15, 2011 10:14:39 AM

Page 1

Work Order ID: 67314

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD10 NAS1149D0363J Purchased

No

105

Each

24.0000

3

6



Washer



M116583

11/3/21 SP

Location

Loc Qty

Loc Code

ST298

24

105792

2

107715

6

112279

16

Manufactured

No

105

Each

77.0000

3

6

D2237



Striker Plate



11/3/21 SP

Location

Loc Qty

Loc Code

ST009

77

64426

3

64762

10

66139

64

Manufactured

No

105

Each

17.0000

3

6

D2583



Latch Bracket



11/3/21 SP

2x

Location

Loc Qty

Loc Code

ST017

17

56527

1

66166

16

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, March 15, 2011 10:14:39 AM

Work Order ID: 67314

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

D2585

Manufactured No

105

Each

49.0000



Mounting Channel

3 6 11/3/21

Location

Loc Qty

Loc Code

ST017

49

64761

7

66142

42

Manufactured No

105

Each

118.0000

D2586



Door Latch

3 6 11/3/21

Location

Loc Qty

Loc Code

ST204

118

64656

18

64774

100

Manufactured No

105

Each

34.0000

D2587



Door Slug, 350 Hinge

1 2 11/3/21

Location

Loc Qty

Loc Code

ST017

34

64314

6

66836

28

Manufactured No

105

Each

94.0000

D2589



Keys, Key Chain, 350 Hinge

1 2 11/3/21

Location

Loc Qty

Loc Code

ST018

94

58194

94

Tuesday, March 15, 2011 10:14:40 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, March 15, 2011 10:14:40 AM

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Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

MS20470AD4-5

Purchased

No

105

Each

1,462.000

6 12



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1462

116410

106

116893

1356

105

Each

2,342.000

3 6

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

2342

116391

742

116540

800

116549

800

105

Each

111.0000

3 6

MS27039-1-15

Purchased

No



Screw

Location

Loc Qty

Loc Code

ST292

111

114718

1

116169

10

116916

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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